

## PROVISION FOR UPKEEP

ture *F* is also of cast iron and has a bearing all around on the base, while the central stud *C* is used as a locator for the work at its upper end, and holds the revolving portion down firmly by means of the nut and collar at *H*. The fitting at this point is such that the fixture may be revolved readily and yet is not free enough so that there is any lost motion. A liner bushing of hardened steel is ground to a nice fit on the central stud at *E*

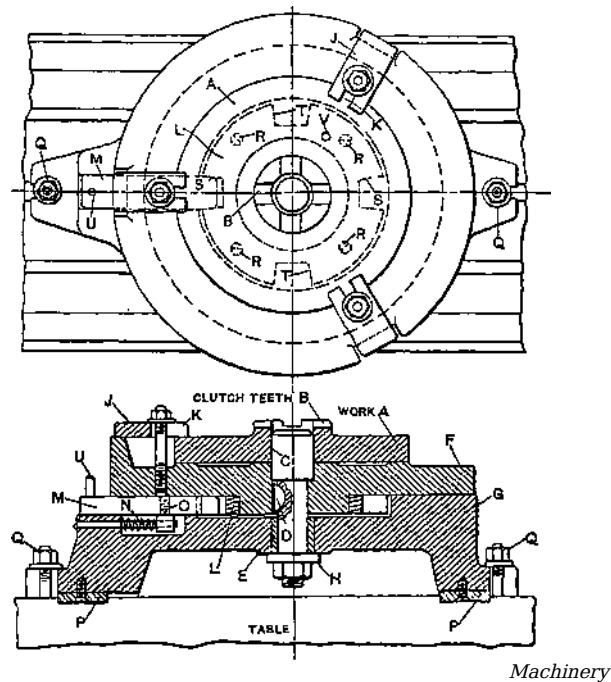


Fig. 3. Indexing Fixture used for Milling Teeth in Clutch Gear

and will wear almost indefinitely, while an indexing ring *L* is forced on the revolving portion *F* of the fixture, and doweled in its correct position by the pin *V* and held in place by the four screws *R*. The work is held down firmly on the revolving portion by means of the three clamps *I*, these being slotted at *K* to facilitate rapid removal.

A steel index bolt *M* of rectangular section is carefully fitted to the slot in the body of the fixture, and beveled at its inner